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IS 2351 (1988): Marble Stoppered Aerated Water Glass Bottles [CHD 10: Glassware]

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Indian Standard

(Reaffirmed 1998)

SPECIFICATION FOR MARBLE STOPPERED AERATED WATER GLASS BOTTLES

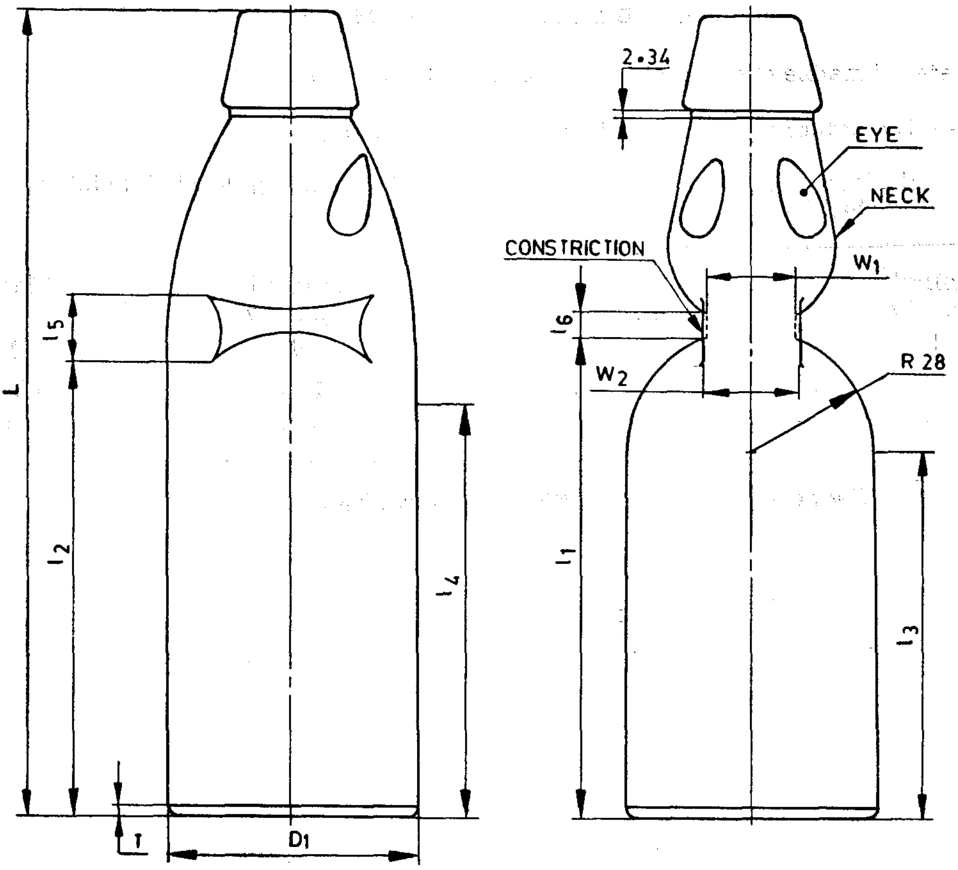
(*First Revision*)

1. Scope — Lays down the requirements for marble stoppered aerated water glass bottles of Codd's pattern.

2. Terminology — For the purpose of this standard, the definitions as given in IS : 1382-1981 'Glossary of terms relating to glass and glassware (*first revision*)' and IS : 6654-1982 'Glossary of terms relating to glass containers (*first revision*)' along with the terms given in Fig. 1 shall apply.

3. Nominal Capacity — The bottles shall be of 200 and 300 ml nominal capacity.

Glass Containers Sectional Committee, MCPD 13 [Ref : Doc : MCPD 13 (762)]



Nominal Size	Dia D_1	L	l_1	l_2	l_3	l_4	l_5	l_6	T	W_1	W_2
200 ml	65±1	209·5	125	119	98·5	108·5	12	4·0	2·5	22·5	24·75
300 ml	65±1	241·0	143·7	135	116·8	138·0	19	2·7	4·5	23·4	26·00

Note — Dimensions l_3 and l_4 are straight height of bottle.

All dimensions in millimetres.

FIG. 1 DIMENSIONS OF THE BOTTLES

Adopted 13 June 1988

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Gr 2

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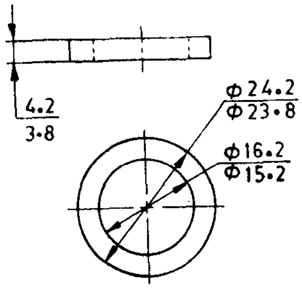
NEW DELHI 110002

4. Dimensions

4.1 The dimensions for the bottles shall be as given in Fig. 1.

4.2 The ring shall have dimensions as given in Fig. 2.



All dimensions in millimetres.

FIG. 2 DIMENSIONS FOR RUBBER RING

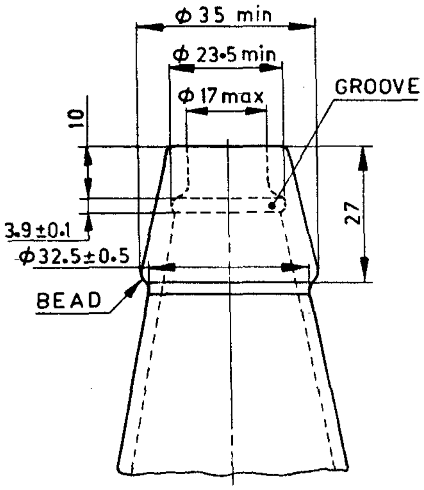
4.3 The diameter of marble shall be within the range of 18·0 to 17·5 mm.

5. Material — The bottles shall be manufactured from suitable glass.

6. Capacity and Mass — The nominal capacity, capacity at filling level, brimful capacity and the mass of the bottles shall be as follows:

Nominal Capacity	Capacity at Filling Level	Brimful Capacity	Mass
ml	ml	ml	g
200	200±4	250	630
300	300±6	355	690

7. Neck Finish — The neck finish of the bottle shall be as given in Fig. 3.



All dimensions in millimetres.

FIG. 3 DIMENSIONS FOR NECK FINISH

8. General Requirements

8.1 The glass used for the manufacture of bottles shall be as free as possible from cords, seeds, blisters and stones. It may be colourless or coloured, as required.

8.2 The junction between the side wall and the bottom shall be well rounded.

8.3 The heel and the bottom shall be shaped to ensure stability. The groove shall be of sufficient size to grip the ring well and not allow it to rotate and also to prevent the marble from falling out without the ring. The rubber ring shall seat firmly inside the groove and shall not protrude from either above or below the groove.

8.4 *Annealing* — The bottles shall be well annealed.

9. Tests

9.1 *Hydrostatic Pressure Test* — The bottle shall pass the test as prescribed in Appendix A.

10. Packing and Marking

10.1 The bottles shall be packed as agreed to between the purchaser and the vender.

10.2 Each bottle shall be permanently and legibly marked with the manufacturers name or his registered trade-mark and the nominal capacity.

10.3 *Standard Marking* — Details available with the Bureau of Indian Standards.

APPENDIX A

(*Clause* 9.1)

HYDROSTATIC PRESSURE TEST

A-1. Apparatus — The apparatus shall embody the following principles.

A-1.1 The bottle to be tested shall be held by a split collar so designed that the bottle is not clamped but is suspended from the bead of the finish.

A-1.2 A seal shall be provided which should be water-tight at the pressure to be applied.

A-1.3 An automatically controlled timing mechanism shall be built into the machine so that the bottle is under pressure for $1{\cdot}00 \pm 0{\cdot}02$ minutes.

A-1.4 The apparatus shall be so designed that the weight is applied directly by gravity without any intermediate cams or levers.

A-2. Procedure

A-2.1 Fill the bottle with water at room temperature. Hold it by the split collar and then seal. Apply a pressure of 200 N/cm^2 ($\approx$20 kgf/cm^2) and release the pressure automatically at the end of one minute.

A-2.1.1 A bottle which withstands the pressure without bursting shall be considered to have passed the test.

EXPLANATORY NOTE

This standard lays down the requirements for marble stoppered aerated water glass bottles. This standard was first issued in 1963 and was reaffirmed in 1979. The present revision has been taken up to bring this standard in line with the current manufacturing practices.

Marble stoppered glass bottles are used in considerable quantities as containers for aerated water, in several parts of the country. It has been felt necessary that the bottles used for aerated water should be of sound design so that they do not affect the health, safety and convenience of the personnel engaged in the manufacture and the packing of aerated water, and also of the general public while opening the bottle. In order to prevent accidents and to ensure the supply of safe bottles, formulation of this standard has been taken up.

Printed at Printrade, New Delhi, India